

Date: Friday, 5/25/2007 8:26:12 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE, INBOARD, LS, 206
Job Number : 32624	
Estimate Number : 10820	
P.O. Number : <u>N/A</u>	Part Number : D26661
This Issue : 5/25/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2666 REV. D
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 29668	Material : <u>N/A</u>
Written By : _____	Due Date : 6/30/2007 Qty: <u>2</u> Um: Each
Checked & Approved By : <u>07.05.28</u>	
Comment : Est: C 0011.01 Removed P/O for Powder Coat - in house processEC	
Est Rev:D As per Rev D 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 7075-T7351 2X6X6.25
 Issue material from stock:
 Cut Size 2.0 x 6.25 X 6.0
 Grain Along Long 6.0 Length

Batch No: 3138607.09.20

(2)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Fixturing Inspection last completed on N/A by N/A
 3-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
 6-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
 8-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
 9- Deburr

07.09.20

(2)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

07.09.20

(2)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07.09.20

(2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/09/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:26:12 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 32624

Part Number: D26661

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L. 07/09/20

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 07/09/20 (2)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.L. 07/09/21

M1105068

(2X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

EP 07/09/24 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/09/24 (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2)
D 07/09/25

Job Completion



W 07-09-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 32624
Description: 206 Saddle, Inboard, Left side	Part Number: D2666-1
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.127	.127				
B	0.100	0.140		.120	.120				
C	2.470	2.510		2.497	2.497				
D	0.100	0.180		.135	.135				
E	0.210	0.230		.127	.127				
F	1.313	1.343		1.330	1.330				
G	0.240	0.260		.255	.255				
H	0.615	0.685		.650	.650				
I	1.125	1.145		1.139	1.139				
J	0.990	1.010		1.000	1.000				
K	0.235	0.240		.239	.239				
L	0.510	0.515		.510	.510				
M	0.100	0.120		.115	.115				
N	1.565	1.585		1.575	1.575				
O	5.990	6.010		6.010	6.010				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.490	0.510		.505	.505				
S	0.313	0.318		.314	.314				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.315	0.322		.319	.319				
W	0.540	0.560		.556	.556				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.258	.258				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>SE</i>
Date: 07.09.20

Audited by: <i>J.L.</i>
Date: 07/09/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 32624
Description: 206 Saddle, Inboard, Left side	Part Number: D2666-1
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140							
B	0.100	0.140							
C	2.470	2.510							
D	0.100	0.180							
E	0.210	0.230							
F	1.313	1.343							
G	0.240	0.260							
H	0.615	0.685							
I	1.125	1.145							
J	0.990	1.010							
K	0.235	0.240							
L	0.510	0.515							
M	0.100	0.120							
N	1.565	1.585							
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AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
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DART AEROSPACE LTD	Work Order: 32624
Description: 206 Saddle, Inboard, Left side	Part Number: D2666-1
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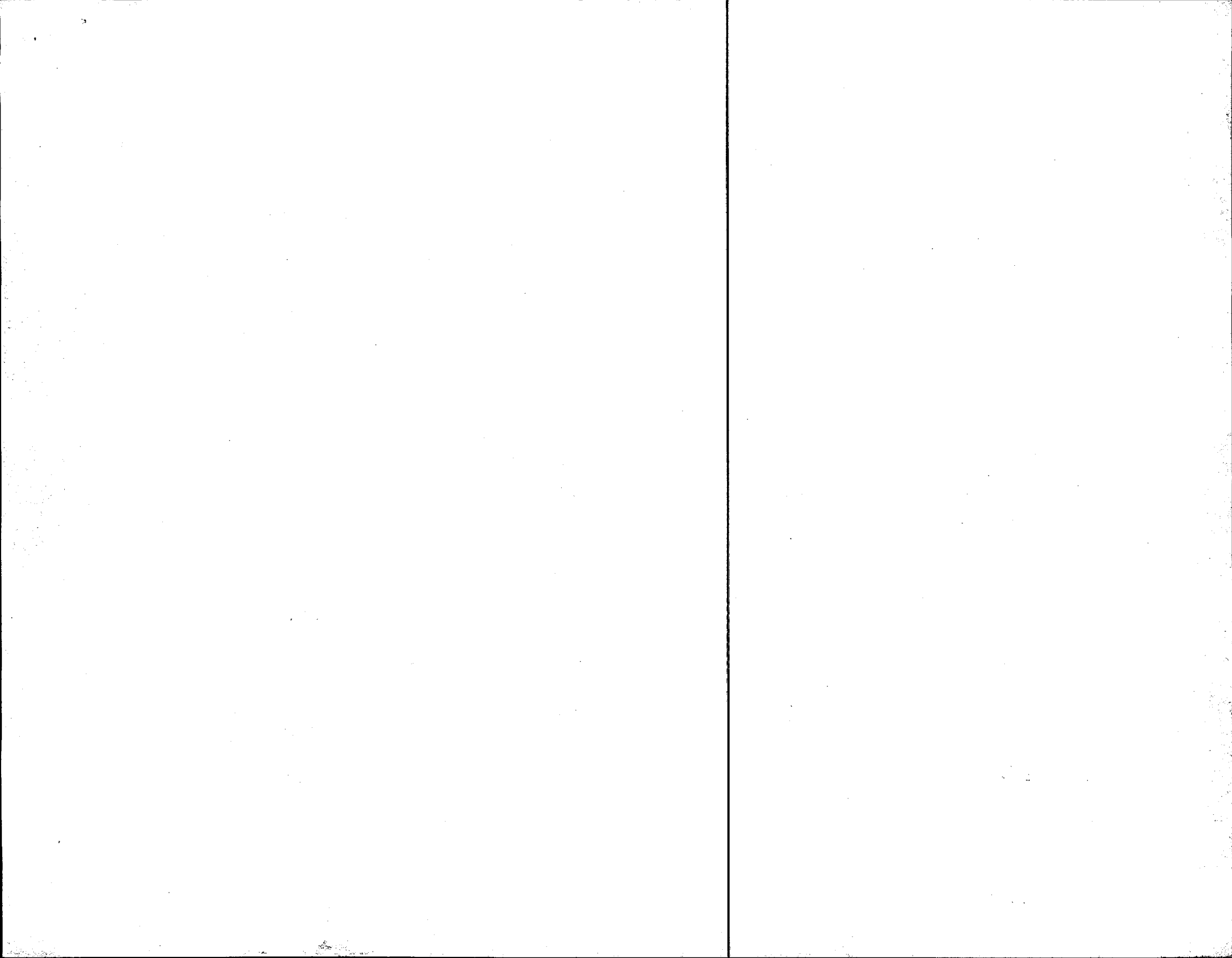
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Accept/Reject									

Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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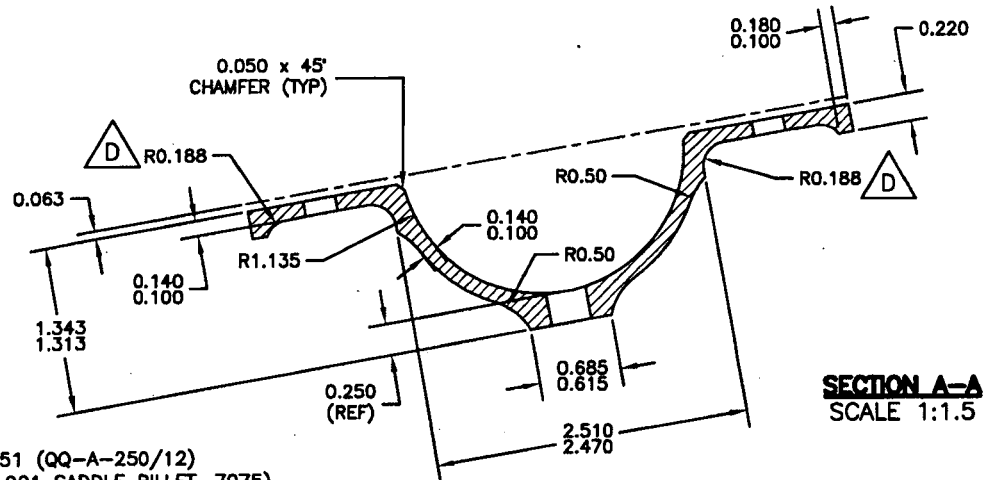


DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

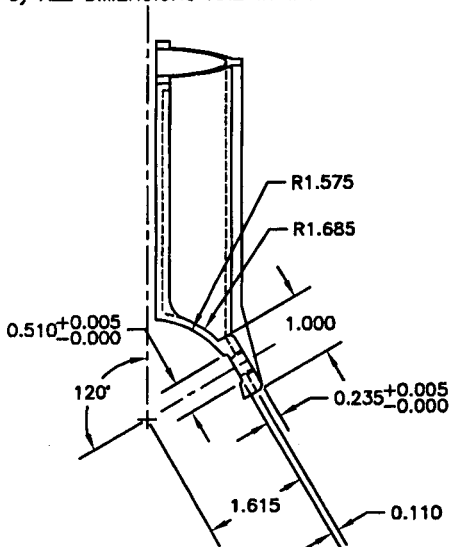
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07.02.12

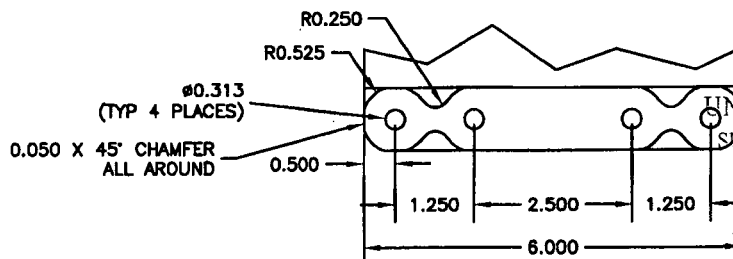
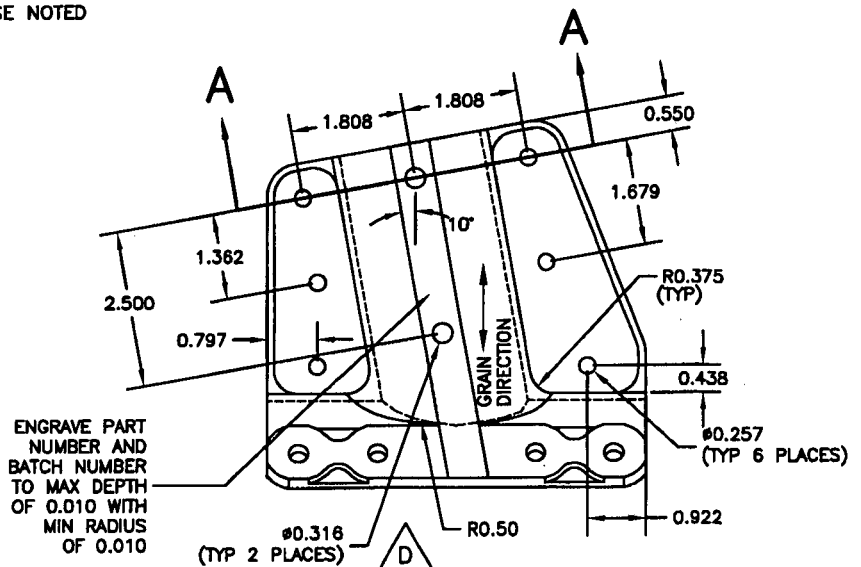


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2666-1 SADDLE FWD INSIDE HIGH

SHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 32624

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